										DQA.	Date	
NCR: Y	es / No				WORK ORDER NON-	CONF	ORN	MANCE / UPDATE			20.0	
										QA Closed:	Date	
Work Orde	er:				DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS	
Part N	Part No				Rework Scrap Use-as-is	Scrap Machining Small Fab				4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
NCKI					Work Order Update Large Fab Compos				re[_	1	Supplier	
Root				Descri	ption of work order update	Init	ial	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Description		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved				4							4	
						FAULT (	CATE	GORY	_	15		
Landir	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend				General  Bend  BOM/Route  Broken/Damaged  Burrs  Contamination  Courisink  Cut Too Short  Drill Holes	Ha Ins Ins M Mi Mi	structi ainte islabe isread fset	on Incomplete ons Incomplete/Unclear nance led		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	ssing «	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Torque Waves in Extrusion				Drawing	lor	If of C	alibration				

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish

May-13-13 12:40:06 PM

Item ID:

D3065-5

Accept

\*N900040100\*

Setup Start

Revision ID:

Start Date:

Item Name: Step Leg

Required Date: 5/20/13

5/13/13

OC:

Start Qty: 160.00

Req'd Qty: 160.00

\*160\* \*160\*

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Date: Tooling:

SPC (Y/N):

Date: Date: Run Start

Stop

Sequence ID/	
Work Center II	D
130	
*130*	

Operation Description

Chemical Conversion Coat per QSI005 4.1

Set Up/ **Run Hours** 0.00

Tool ID

Tool# Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

HandFinish Hand Finishing

Memo

0.00

140

\*140\* QC

Quality Control

OCI - Inspect Part Finish

Memo

0.00

0.00

150

\*150\*

Packaging

Packaging

Identify as per dwg & Stock Location.

Memo

0.00

0.00

										DQA	: Date	<u>:</u>	
NCR: Y	es / No				WORK ORDER NON	-CO	NFORM	/IANCE / UP	DATE				
										QA Closed	: Date	2:	
Work Orde	r.				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part N					Rework Scrap		Skid-tube Crosstube Machining Small Fab			Pro	Water Jet	Engineering Quality	
	NCR No.				Use-as-is Work Order Update	Use-as-is Thermoforming Finishing				-	ore/Packaging Supplier	Other	
Hen Ho.					Work Order opdate			carge rab	composite		Supplier		
Root Cause	Date	Step	Qty		otion of work order update or Non-conformance		Initial nief Eng		tion ription	Sign & Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
					**	FAUI	LT CATE	GORY					
Landin	ng Gear Bending				General Bend		Grain		Г	Ovalized	Ĺ	Pressure/Forced	
	Centre Not Concentric to O/S Cracks				BOM/Route Broken/Damaged	F	Hardwa	re on Incomplete	F	Over/Unde	A STANDARD SAN DANA D	Temperature/Cure Weld	
	Crushed/Crimped				Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/N	lissing	Wrong Stock Pulled	
	Cuffs Heat Treat			Contamination Countersink		Maintenance Mislabeled			Positioned	Wrong	7		
1 1	Inspection Strip in Tube				Cut Too Short		Misrean			Power Loss	Surge	Other	

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

\*101458\*

Page 3

May-13-13 12:40:06 PM Item ID: D3065-5 Accept \*N900040100\* Setup Start Revision ID: Item Name: Step Leg 5/13/13 \*160\* Start Date: Start Qty: 160.00 Cust Item ID: Required Date: 5/20/13 Req'd Qty: 160.00 \*160\* **Customer:** Reference: Run Start Approvals: Process Plan: Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Reject Tool# Plan Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 160 QC21- Final Inspection - Work Order Release 0.00 \*160\* 0.00 Memo Quality Control

PL13-06-3

	000000000000000000000000000000000000000	### G00000
NCR:	Yes /	No
IACIT.	103 /	140

Date:

DQA:

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE												
									QA Closed:	Date:		
Work Order	r:				DISPOSITION			AGAINST DE	DEPARTMENT/PROCESS			
	-				Rework	1	Skid-tube	Crosstube	1	Water Jet	Engineering	
Part No	0.				Scrap		Machining Small Fab			d. Eng. Coor.	Quality	
					Use-as-is	Ther	moforming	Finishing	Rec/Stor	re/Packaging	Other	
NCR N	0				Work Order Update	]	Large Fab	Composite	e Supplier Supplier			
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &			
Cause	Date Step Qty				or Non-conformance	Chief En	g Desc	ription	Date	Verification	QC Inspector	
Doc/Data												
quip/Tooling												
Operator		1	1 1									
Material			1 1									
Setup												
Other			1 1							1		
Process						1						
Supplier			1 1							V		
Training						l						
Jnapproved												
					F	AULT CAT	EGORY					
Landin	g Gear			_	General			_	-		7	
	Bending				Bend	Grain			Ovalized	_	Pressure/Forced	
	Centre N	ot Conce	ntric to (	O/S	BOM/Route	Hardv	are		Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld	
	Crushed/	Crimped			Burrs	Instru	ctions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs				Contamination	Main	tenance		Part Moved			
	Heat Trea	at			Countersink	Misla	eled		Positioned V	Vrong	_	
	Inspectio	n Strip in	Tube		Cut Too Short	Misre	ad		Power Loss/	Surge	Other	
	Ripples in	n Bend			Drill Holes	Offset						
Ī	Torque V	Vaves in	Extrusion	1	Drawing	Out o	Out of Calibration					
Ī	Turning S				Finish	Out o	Out of Sequence					
	Wave/Twist in Tube				Folio	Outsid	de Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

### **Picklist Print**

May-13-13 12:40:09 PM

Work Order ID: 101458

Parent Item: D3065-5

Parent Item Name: Step Leg

\*101458\* \*D3065-5\*

Start Date: 5/13/13 Start Qty: 160.00

Required Date: 5/20/13

Required Qty: 160.00

Comments:

IPP: C02.11.01Incorporated D3066-1 IPPKJ/RF IPP Rev:D Now on Water Jet 06-04-11 JLM

IPP Rev:E Now manufactured with 6061-T6 06-05-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M6061T6S.080		Purchased	No			100	sf	112.5973	0.825	138,947	=			
*M6061T6	S 080*								**	46	112.1	-	JMB.	5-1

6061-T6 .080 Sheet

Location Loc Qty Loc Code MAT021 112.597264 0.497264 124786 112.1

12.195 S.F.

										DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-C	10:	NFORM	MANCE / UP	DATE	QA Closed:	Date:	
Work Order:					DISPOSITION	AGAINST DEPARTMENT/PROCESS						
Part No.  NCR No.				Rework Scrap Use-as-is Work Order Update	Therm		Skid-tube Crosstube  Machining Small Fab  rmoforming Finishing  Large Fab Composite		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other	
Root				Descri	ption of work order update	1	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other												

### Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Ovalized Pressure/Forced Bend Grain Bending Temperature/Cure Over/Under tolerance Centre Not Concentric to O/S BOM/Route Hardware Inspection Incomplete Part Incorrect Weld Broken/Damaged Cracks Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped Burrs Part Moved Cuffs Contamination Maintenance Positioned Wrong Heat Treat Countersink Mislabeled Other Power Loss/Surge Inspection Strip in Tube Cut Too Short Misread **Drill Holes** Offset Ripples in Bend Drawing Out of Calibration Torque Waves in Extrusion Out of Sequence Turning Sequence Finish Folio Outside Dimensions Wave/Twist in Tube

Process

DART AEROSPACE LTD	Work Order:	01458
Description: Step Leg	Part Number:	D3065-5
Inspection Dwg: D3065 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.458	+/-0.010	16.458	-		ナ	Jenos
15.750	+/-0.005	15.750"	-		T	
2.250	+/-0.005	2.249"	-		v	J&ma)
3.460	+/-0.005	3.457	-		V	
0.865	+/-0.005	0.870"	-		V	
6.020	+/-0.005	6.019"	-		V	
1.205	+/-0.005	1.203	<u> </u>		V	
3.484	+/-0.005	3.486	-		V	
0.871	+/-0.005	0.876"	_		V	
8.325	+/-0.010	8.331	~		V	Productor.
0.551	+/-0.010	0.554"	-		ν	
0.213	+0.005/-0.000	0.215	-		V	
Ø0.128	+0.005/-0.000	0.129"	· ·		V	
	¢.					
					A THE RESERVE	N. Carr

Measured by:	Jm	Audited by:	5nD	Prototype Approval:	N/A
Date:	13-5-17	Date:	15500	Date:	N/A

Rev	Date	Change	Revised by Approve
Α	03.09.22	New Issue P/O D3065-041	KJ/RF
В	04.06.15	Added Ø0.128 dimension	KJ/JLM 10
С	06.06.23	Dwg Rev. changed	KJ/JLM A CAN

											DQA:	D	ate:	
NCR: Y	res / No				WORK ORDER NON-C	O	NFORM	ЛANC	CE / UPD	DATE	QA Closed:		ate:	
					DISPOSITION					AGAINST DE			otc.	
Work Orde	er:				Rework	1	Skid-tube Crosstube			Water Jet			Engineering	
Part N	No				Scrap Use-as-is	Machining Small Fab Thermoforming Finishing			Prod. Eng. Coor.  Rec/Store/Packaging			Quality		
NCR No.					Work Order Update	Large Fab Composite				Supplier				
Root				Descrip	ption of work order update	1	nitial		Acti	on	Sign &			
Cause	Date	Step	Qty	C	or Non-conformance	Ch	ief Eng		Descri	ption	Date	Verificati	on	QC Inspector
Doc/Data														
Equip/Tooling			1 1				- 1							
Operator														
Material		1												
Setup														
Other							1							
Process							1							
Supplier														
Training		1												
Unapproved														
					F	AUL	T CATE	GORY				M		
Landir	ng Gear			8	General					-				
	Bending				Bend		Grain				Ovalized			Pressure/Forced
	Centre N	ot Conce	ntric to 0	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
	Cracks	<del> </del>			Broken/Damaged		Inspecti	on Inco	mplete		Part Incorre	ct		Weld
	Crushed	Crimped			Burrs		Instruct	ions Inc	omplete/U	nclear	Part Lost/M	issing		Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance			Part Moved			
	Heat Tre	at			Countersink		Mislabe	led			Positioned \	<b>Vrong</b>	20	
	Inspection	Inspection Strip in Tube			Cut Too Short		Misread	1			Power Loss,	/Surge		Other
	Rinnles in	Ripples in Bend			Drill Holes		Offset			_				

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

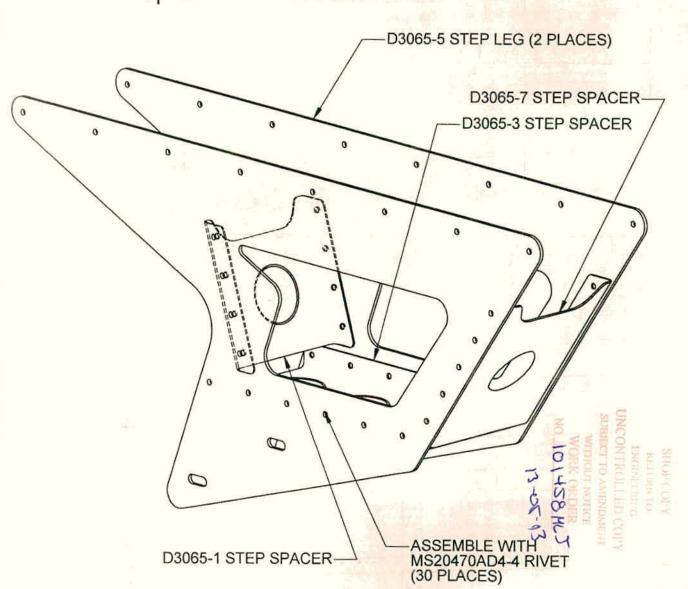
Drawing

Finish



DESIG	4	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA						
CHECK	PH	APPROVED	DRAWING NO. D3065	REV. B SHEET 1 OF 5					
DATE	06.0	05.23	STEP LEG ASSEMBLY	SCALE 1:2					
А	0	2.09.11	NEW ISSUE						
В	0	6.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5						

# RELEASED



## D3065-041 STEP LEG ASSEMBLY

				DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-C	WORK ORDER NON-CONFORMANCE / UPDATE				
Work Order:	DISPOSITION	DISPOSITION AGAINST DEP				
Part No	Rework Scrap Use-as-is Work Order Update	Therm	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause Date Step Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data  Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		AULT CATE				

Countersink Mislabeled Positioned Wrong Heat Treat Other Misread Power Loss/Surge Inspection Strip in Tube Cut Too Short **Drill Holes** Offset Ripples in Bend Out of Calibration Torque Waves in Extrusion Drawing Out of Sequence Turning Sequence Finish Wave/Twist in Tube Folio Outside Dimensions

Grain

Hardware

Maintenance

Inspection Incomplete

Instructions Incomplete/Unclear

Pressure/Forced

Weld

Temperature/Cure

Wrong Stock Pulled

Ovalized

Part Incorrect

Part Moved

Part Lost/Missing

Over/Under tolerance

General

Bend

Burrs

BOM/Route

Contamination

Broken/Damaged

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**Landing Gear** 

Bending

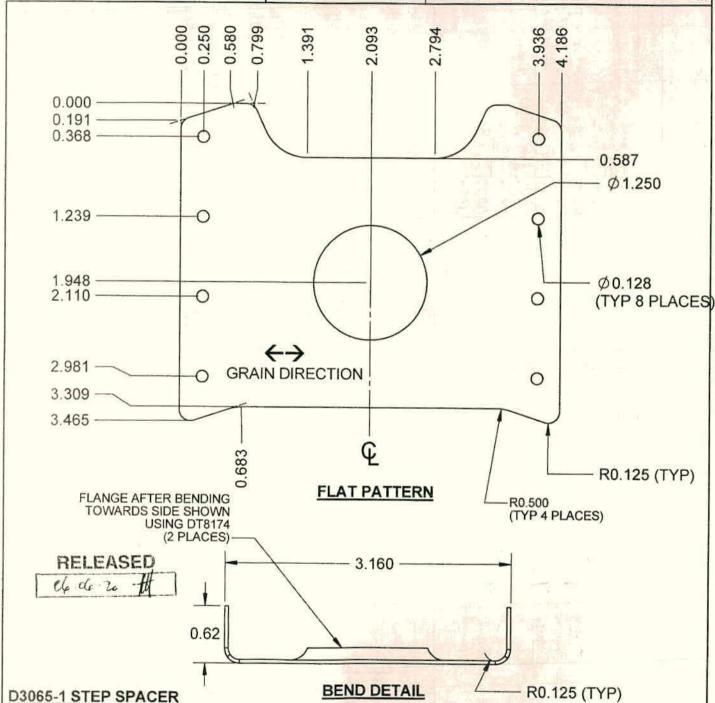
Cracks

Cuffs

Crushed/Crimped

Centre Not Concentric to O/S





- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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											DQA:	Dat	e: _	
NCR:	res / No				WORK ORDER NON-	COI	NFOR	MANCE ,	/ UPI	DATE				
											QA Closed:	Dat	e:	
Work Orde	ar:				DISPOSITION			AGAINST DEPARTMENT/PROCESS						
Work Order: Part No.					Rework Scrap Use-as-is	Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing			Section 2010 Contract	Water Jet Prod. Eng. Coor. Rec/Store/Packaging			Engineering Quality Other	
NCR No.				Work Order Update	Large Fab Composite			Composite		Supplier				
Root				Descri	ption of work order update		Initial		Act	ion	Sign &			
Cause	Date	Step	Qty	(	or Non-conformance	Ch	nief Eng		Descr	iption	Date	Verification	1	QC Inspector
Doc/Data														
Equip/Tooling		1				1								
Operator														
Material		1												
Setup		1	1											
Other		1												
Process		1												
Supplier		1												
Training														
Unapproved		1												
					F	AUL	T CATE	GORY						
Landi	ng Gear				General					19-	12)			
CALIFORNIA (CALIFORNIA CALIFORNIA	Bending				Bend		Grain				Ovalized		P	ressure/Forced
	Centre N	lot Conce	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance	T	emperature/Cure
	Cracks				Broken/Damaged		Inspect	on Incompl	lete		The state of the s		V	Veld
		/Crimped			Burrs		-	ions Incom		Inclear	Part Lost/Mi	ssing	V	Vrong Stock Pulled
	Cuffs				Contamination	Maintenance			Part Moved	-				

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Countersink

Cut Too Short Drill Holes

Drawing

Finish

Folio

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

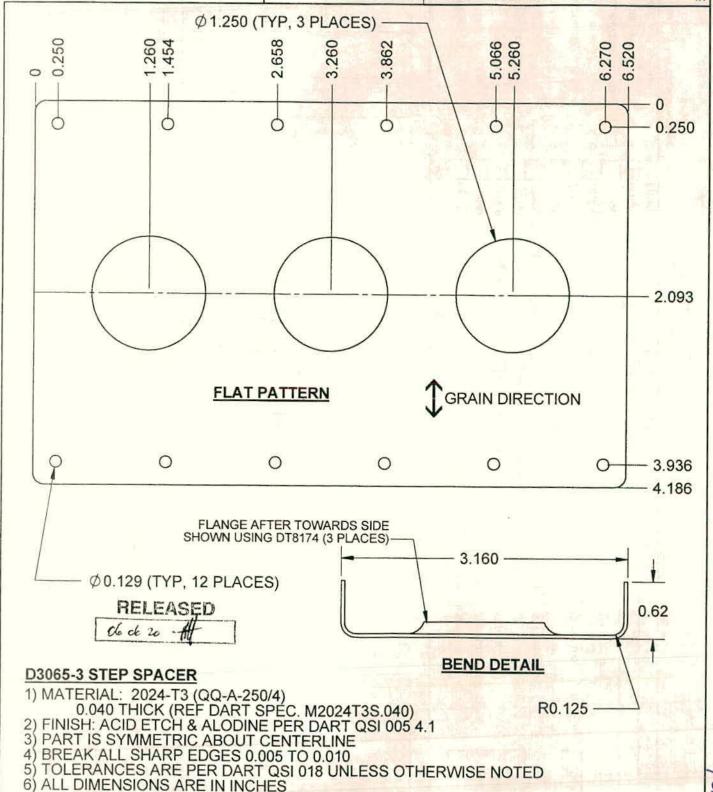
Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion







NCR: Yes	/ No			WORK ORDER NON	WORK ORDER NON-CONFORMANCE / UPDATE								
	,							QA Closed:	Date:	<u> </u>			
Work Order:				DISPOSITION	DISPOSITION AG.				NST DEPARTMENT/PROCESS				
Part No.				Rework Scrap Use-as-is Work Order Update	Use-as-is Thermoforming Finishing			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other			
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng		tion ription	Sign & Date	Verification	QC Inspector			
Doc/Data  Equip/Tooling Operator Material Setup Other Process Supplier Training													

Pressure/Forced Grain Ovalized Bending Bend Over/Under tolerance Temperature/Cure BOM/Route Centre Not Concentric to O/S Hardware Part Incorrect Weld Cracks Broken/Damaged Inspection Incomplete Wrong Stock Pulled Burrs Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped Part Moved Cuffs Maintenance Contamination Countersink Mislabeled Positioned Wrong Heat Treat Other Misread Power Loss/Surge Inspection Strip in Tube Cut Too Short **Drill Holes** Offset Ripples in Bend Out of Calibration Torque Waves in Extrusion Drawing Out of Sequence Turning Sequence Finish Wave/Twist in Tube Folio Outside Dimensions

**FAULT CATEGORY** 

General

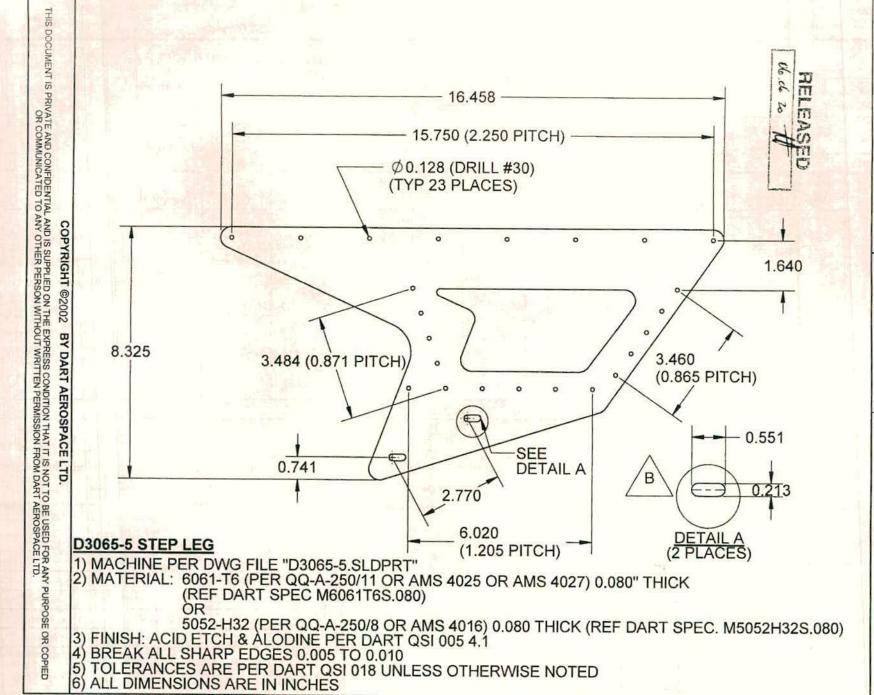
H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Unapproved

**Landing Gear** 

DATE 06.05.23 2 D3065 STEP F DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA 0 ASSEMBLY SHEET 4 OF 5 REV. B

SCALE



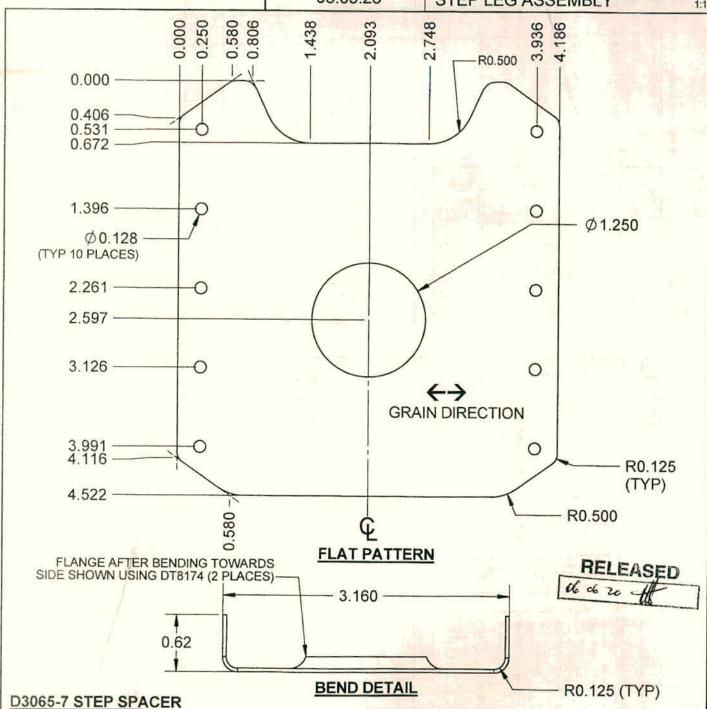
							DQA:	Date:	380		
NCR: Yes	/ No			WORK ORDER NON-	WORK ORDER NON-CONFORMANCE / UPDATE						
Work Order:				DISPOSITION				AGAINST DEPARTMENT/PROCESS  ube Crosstube Water Jet			
Part No				Scrap Use-as-is Work Order Update	Therm	Machining Small Fa noforming Finishin Large Fab Composit	Rec/Store	I. Eng. Coor.  e/Packaging  Supplier	Quality Other		
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data  Equip/Tooling Operator Material Setup Other											

**FAULT CATEGORY Landing Gear** General Pressure/Forced Ovalized Bend Grain Bending Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S BOM/Route Hardware Inspection Incomplete Part Incorrect Weld Broken/Damaged Cracks Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Crushed/Crimped Burrs Part Moved Cuffs Contamination Maintenance Positioned Wrong Heat Treat Countersink Mislabeled Other Power Loss/Surge Misread Inspection Strip in Tube Cut Too Short **Drill Holes** Offset Ripples in Bend Drawing Out of Calibration Torque Waves in Extrusion Turning Sequence Out of Sequence Finish Folio Outside Dimensions Wave/Twist in Tube

Process Supplier Training Unapproved



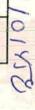




- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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700000										DQA:	Date:			
NCR: Y	es / No				WORK ORDER NON-CONFORMANCE / UPDATE					QA Closed:	Date:			
Work Order:					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No			Rework Scrap Use-as-is Work Order Update		Machining Small Fa Thermoforming Finishin		Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other				
Root				Descrip	tion of work order update	Initia	21	Act	tion	Sign &				
Cause	Date	Step	Qty	C	r Non-conformance	Chief E	ng	Descr	ription	Date	Verification	QC Inspector		
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved									est.					
					F	AULT CA	TEGORY							
Landin	Bending				General Bend	Grai	n			Ovalized		Pressure/Forced		
	Centre Not Concentric to O/S BOM/Route						lware			Over/Under	tolerance	Temperature/Cure		
	Cracks				Broken/Damaged	Insp	ection Incom	plete		Part Incorre	-	Weld		
	Crushed/	Crimped			Burrs	Instr	uctions Incor	mplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled		
- [	Cuffs				Contamination	Mai	ntenance			Part Moved				
	Heat Trea	at			Countersink	Misl	abeled			Positioned V	Vrong			

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish